

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021674**Date Inspected:** 25-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

Bay 11

This QA inspector observed ZPMC in process of SMAW welding on Re-Built traveler rail assembly 20TR2-034. ZPMC QC inspector Mao Bin Bin was present at this time of this observation and informed this QA inspector of the work that is in process and identified Zhao Chen Sun as the CWI. It was stated that ZPMC had 5 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- 20TR2-034-009

WPS-B-P-2211-TC-U5b

Welder- 044551

1G/SMAW/CJP

Weld- 20TR2-034-013

WPS-B-P-2211-TC-U5b

Welder- 041713

1G/SMAW/CJP

Weld- 20TR2-034-015

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WPS-B-P-2211-TC-U5b
Welder- 040655
1G/SMAW/CJP

Weld- 20TR2-034-017
WPS-B-P-2211-TC-U5b
Welder- 044541
1G/SMAW/CJP

Weld- 20TR2-034-011
WPS-B-P-2211-TC-U5b
Welder- 040611
1G/SMAW/CJP

The following digital picture illustrates the welding of the Re-Built traveler rail.

Trial Assembly

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Trial Assembly ZPMC was in process of welding on Lift 12. ZPMC CWI Li Yang was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 4 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

CB17
Weld- B-P-3014-017-005 ~ 008
WPS-B-T-2112-ESAB
Welder-040367
2F/FCAW

CB17
Weld- B-P-3014-017-005 ~ 008
WPS-B-T-2114
Welder-044504
4F/SMAW

CB17
Weld- B-P-3017-034, 035
WPS-B-T-2112-ESAB
Welder-047353
2F/FCAW

CB17
Weld- S-P-3026-117, 118
WPS-B-T-2114
Welder-066459

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4F/SMAW

This QA inspector observed ZPMC personnel performing Heat Straightening on CB17 crossbeam. ZPMC CWI Li Yang was present at this time of this observation and informed this QA inspector of the work that is in process. ZPMC CWI stated personnel performing Heat Straightening (HSR1-B-10127) top plate DP3037, DP3036, DP3035, DP3034, CB3001-017-001, 002. QA reviewed heat straightening procedure and observed that heat is being applied per heat straightening procedure requirements and map locations.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

“As noted within the contents of this report.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
